

Ship DEC. 11

Work Order ID 138569

138569

Page 1

Tuesday, November 03, 2015 9:41:39 AM

Item ID: DSI 9603-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Liner

Start Date: 11/23/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/4/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:  Date: 11-11-03

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9603	B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP DSI9603-013 CHG001

BAS
27
9-89DAS
28
9-89

DEC 07 2015

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

BAS
27
9-89
NOV 09 2015

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
28
9-89

DEC 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Liner

Start Date: 11/23/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/4/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI9603-013

Location: store AG FG

1	BAS		
	27		
	9-89		

DEC 02 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

	15/12/3	9
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MCS DEC 03 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Internal Transport ☐	☐	Poor Information ☐		☐	Crushing	☐	Countersink
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Substation ☐	☐	Process Improvement ☐		☐	Marks/Chatter	☐	Drill Holes
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____			
Misidentified ☐	☐	Past Due ☐					

Picklist Print

Tuesday, November 03, 2015 9:41:48 AM

Page 1

Work Order ID: 138569

138569

Parent Item: DSI 9603-013

DSI 9603-013

Parent Item Name: Basket Liner

Start Date: 11/23/2015

Required Date: 12/4/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-03-27 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4628-1		Manufactured	No			110	Each	0.0000	2	2			
D4628-1	DAS								**	138576			
Liner, Face	28												
D4628-3		Manufactured	No			110	Each	0.0000	1	1			
D4628-3	DAS								**	138577			
Liner, Inboard	28												
D4628-5		Manufactured	No			110	Each	0.0000	1	1			
D4628-5	DAS								**	138578			
Liner, Outboard	28												
D4628-7		Manufactured	No			110	Each	0.0000	6	6			
D4628-7	DAS								**	138579			
Liner, Lid	28												
D4628-9		Manufactured	No			110	Each	1.0000	1	1			
D4628-9	DAS								**	138580			
Cover Plate	28												

Location

Loc Qty

Loc Code

Mezz

1

120611

1

AN4-4A

Purchased

No

110

Each

302.0000

98

98

AN4-4A

BOLT

BAS

27

9-89

Location

Loc Qty

Loc Code

FP001

14

m125709

14

ST325A

288

m129390

288

NOV 09 2015

DAS
28
9-89

98

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

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Work Order ID: 138569

138569

Parent Item: DSI 9603-013

DSI 9603-013

Parent Item Name: Basket Liner

Start Date: 11/23/2015

Required Date: 12/4/2015

Start Qty: 1.00

Required Qty: 1.00

AN970-4 Purchased No

110 Each 327.0000 196 196

AN970-4

Washer

BAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST260a

100

m133235

100

ST329

227

129521

207

m129521

20

196

MS21042-4 MS21042L4 Purchased No

110 Each 1.0000 98 98

MS21042-4

Nut / use MS21042L4

BAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST305

1

9063

1

98

m133363

NOV 09 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 REV. D

REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: 10016996

1.0 PURPOSE

This Dart service instruction provides parts and instructions for modifying the basket base assembly of a D350-607-545/-547 Heli-Utility-Basket for installation of scanning equipment.

The DSI 9603-011 kit consists of parts required to modify the basket base assembly of D350-607-545/-547 Heli-Utility-Basket.

The DSI 9603-013 kit is an optional liner kit for customers who wish to add some protection for the equipment that will be installed inside the basket. Customers who wish to procure DSI 9603-013 kit for their D350-607-547 Heli-Utility-Basket modified with DSI 9603-011 must convert their D350-607-547 Heli-Utility-Basket into a D350-607-545 Heli-Utility-Basket using the D350-607-415 Kit. Note that the DSI 9603-013 kit is not waterproof.

2.0 MODIFICATION PROCEDURE (DSI 9603-011):

- 2.1 Disassemble basket and retain hardware.
- 2.2 Locate the D4017-9 Ribs as shown in Figure 1. It is acceptable to trim the D4017-9 Ribs to fit as required.
- 2.3 Transfer mark the location of D4017-9 Ribs onto expanded metal. Ensure there is enough surface contact of the expanded metal strands with the new D4017-9 Ribs.
- 2.4 Trim expanded metal. Remove finish locally on expanded metal and basket base structure where the new D4017-9 Ribs and D4623-1/-3 Bushings will be added.
- 2.5 Weld the new D4017-9 Ribs to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 2.6 Cut center rib. Ensure removal of the center ribs will not damage the attaching ribs of the basket structure.
- 2.7 Locate and weld in place the D4623-1/-3 Bushings as shown in Section A-A.
- 2.8 Tig weld (tack weld) the expanded metal strands to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 2.9 Ensure there is no weld flashings in D4623-1/-3 by cleaning the ID of the bushings with a size 'F' drill ($\phi 0.257$) as required.
- 2.10 Mask ID of D4623-1/-3 Bushings and touch up powder coat of affected areas on the base with white powder coat (4.3.5.2) per Dart QSI 005 4.3 or in accordance with ICA-D350-607.
- 2.11 Modify D4624-1 Supporting Plate per Sheet 3 of this service instruction. Mount D4624-1 plate at the bottom of basket base assembly as shown on Sheet 4 of this service instruction.
- 2.12 Re-assemble basket per ICA-D350-607. Replace any worn hardware as necessary.

3.0 CUTOUTS FOR CAMERAS/LASERS

The following restrictions apply when using/loading the D350-607-545/-547 Heli-Utility-Basket modified per this service instruction:

- 3.1 Cutouts for lasers/cameras that do not exceed half the hatched area of Figure 2 are allowed in the hatched areas. These cutouts must be sealed for flight with a laser/camera.
- 3.2 Lasers/cameras can be mounted to the D4624-1 Plate using appropriate hardware.
- 3.3 After drilling holes/cutouts, touch up finish with alodine and paint D4624-1 using MIL-P-85582 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint.
- 3.4 These instructions do not approve any electrical/electronic modifications required in the aircraft to operate the equipment in the basket.
- 3.5 If a basket modified per DSI 9603 is going to be used to carry loose cargo the cutouts in the D4624-1 Supporting Plate must be covered with blanking plates.

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B	REVISE PARAGRAPH 1.0: EXTEND APPLICABILITY OF DSI 9603-011 TO D350-607-547; ADD COMMENT TO CONVERT D350-607-547 TO -545 FOR FULL INSTALL OF DSI 9603-013	MB	15.01.07
A	NEW ISSUE	MB	12.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. REV. B DSI 9603 SHEET 1 OF 6	
CHECKED		TITLE SCALE BASKET MODIFICATION NTS	
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DE APPR.			
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4.0 INSTALLATION OF LINERS (DSI 9603-013):

- 4.1 Locate the D4628-9 Cover Plate as shown in Figure 3. It is acceptable to trim the D4628-9 to fit as required.
- 4.2 Remove finish locally on basket base structure where the D4628-9 Cover Plate will be added.
- 4.3 Weld the new D4826-9 to the basket tubular structure per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.
- 4.4 Touch up powder coat of affected areas on the base with white powder coat (4.3.5.2) per Dart QSI 005 4.3 or in accordance with ICA-D350-607.
- 4.5 Locate liners as indicated in Figure 3 (basket base) and Figure 4 (basket lid) of this service instruction.
Note: it is acceptable to trim the D4628-1/-3/-5/-7 liners to fit as required.
- 4.6 Locate and drill $\varnothing 0.257$ - $\varnothing 0.281$ " hole through D4628-1/-3/-5/-7 in center of the void of the mesh approx as shown. Deburr.
- 4.7 Secure D4628-1/-3/-5/-7 to basket mesh base/lid using provided AN4 hardware.
- 4.8 As required, it is acceptable to use more AN4 hardware (not supplied).

5.0 PARTS LIST

QTY -011	QTY -013	PART NUMBER	DESCRIPTION
X		DSI 9603-011	BASKET MODIFICATION
	X	DSI 9603-013	LINER
4		D4017-9	RIB
7		D4623-1	BUSHING, SHORT
6		D4623-3	BUSHING, LONG
1		D4624-1	MOUNTING PLATE
	2	D4628-1	LINER, FACE
	1	D4628-3	LINER, INBOARD
	1	D4628-5	LINER, OUTBOARD
	9	D4628-7	LINER, LID
	2	D4628-9	COVER PLATE
	98	AN4-4A	BOLT
7		AN4-12A	BOLT
6		AN4-14A	SCREW
	196	AN970-4	WASHER
13	98	MS21042-4	NUT
26		NAS1149D0463J	WASHER (OR NAS1149D0432J)

6.0 WEIGHT CHANGE:

This modification adds up to 35 lbs (20 lbs from DSI 9603-011 kit + 15 lbs from DSI 9603-013 kit) to the weight of the basket which reduces the cargo carrying capacity of the basket by up to 35 lbs depending on the amount of material removed from the D4624-1 Supporting Plate. See Figure 2 of sheet 4. It is the responsibility of the installer to ensure the limitations of FMS-D350-607 and FMS-D355-607 are not exceeded.

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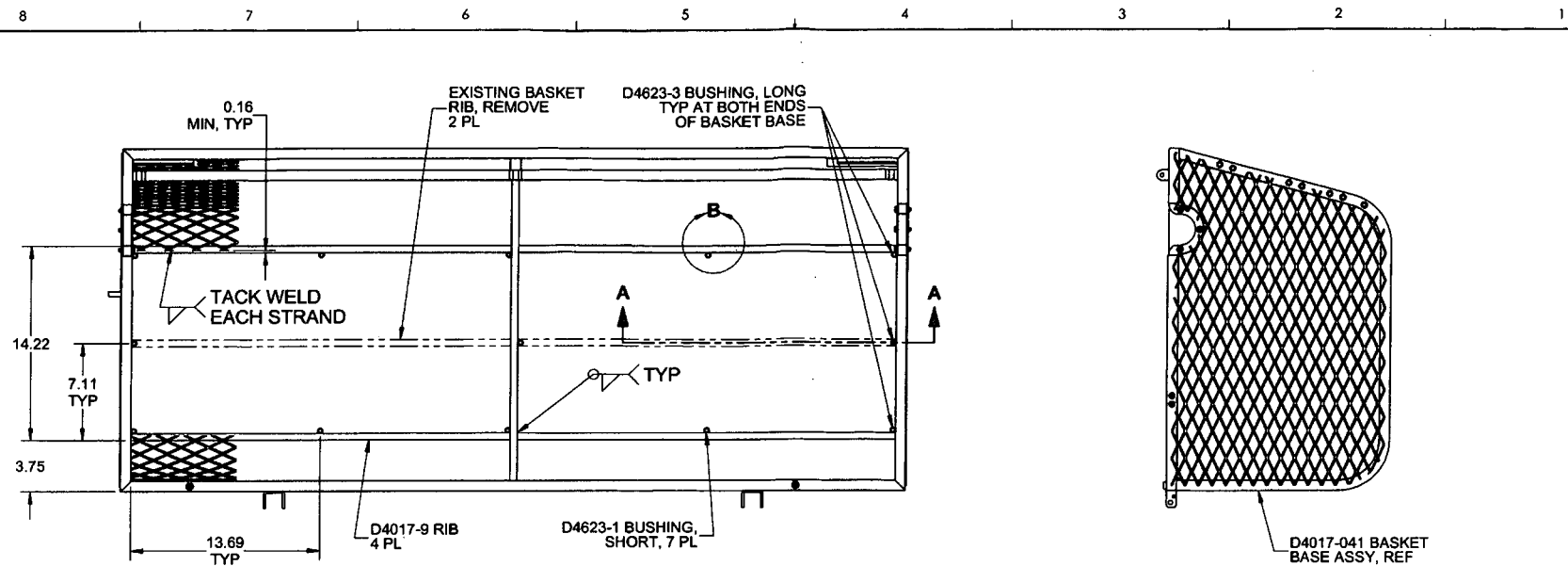
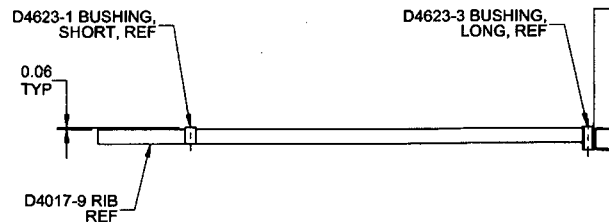
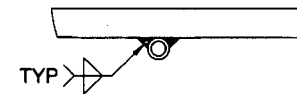


FIGURE 1: MODIFYING THE D4017-041 BASKET BASE ASSY
(MESH SHOWN PARTIALLY FOR CLARITY)



SECTION A-A: BUSHING DETAIL
SCALE 2X



DETAIL B: WELDING DETAIL
SCALE 4X

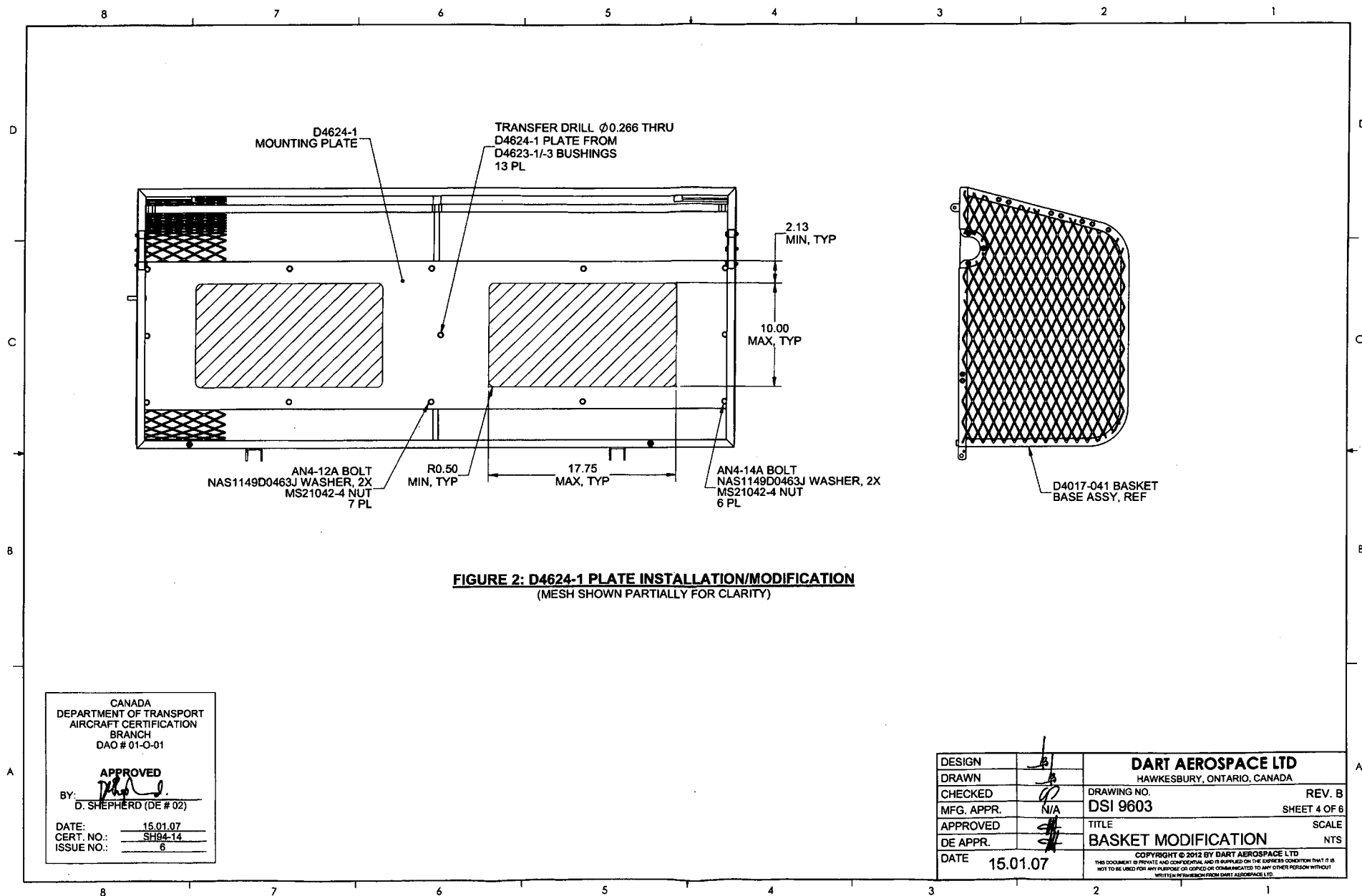
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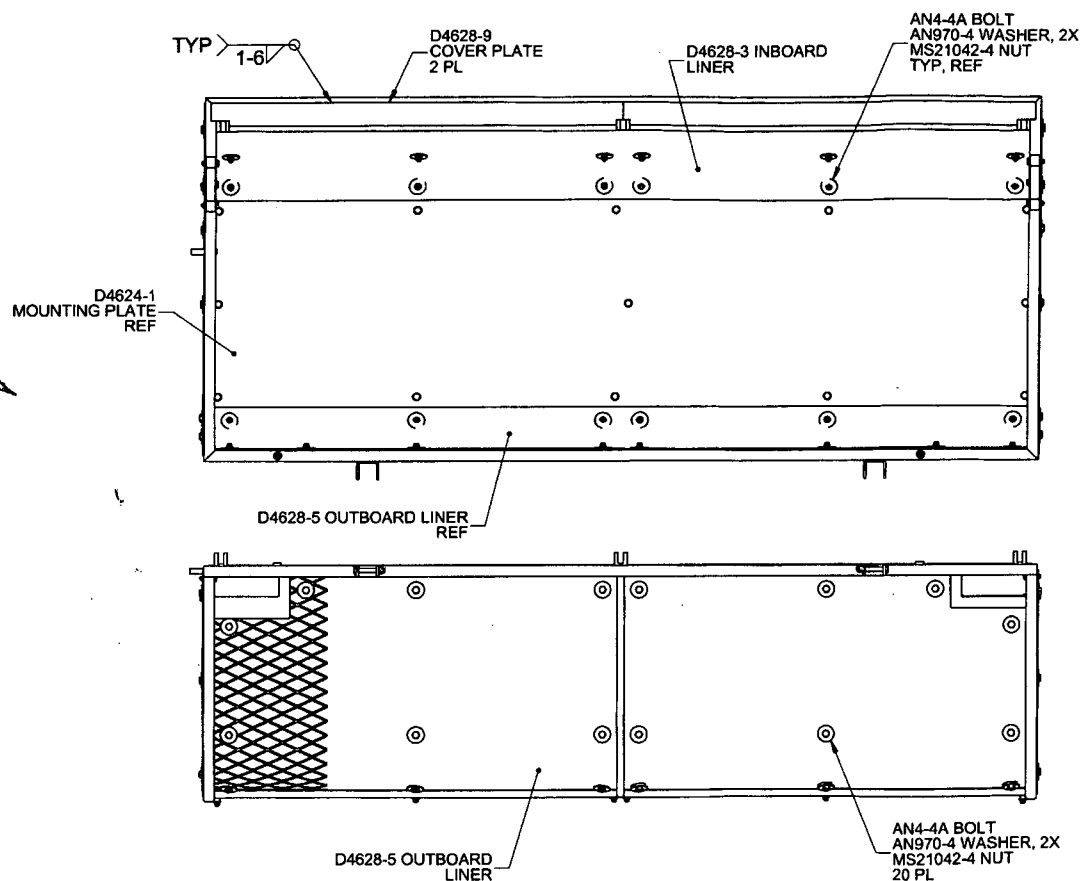


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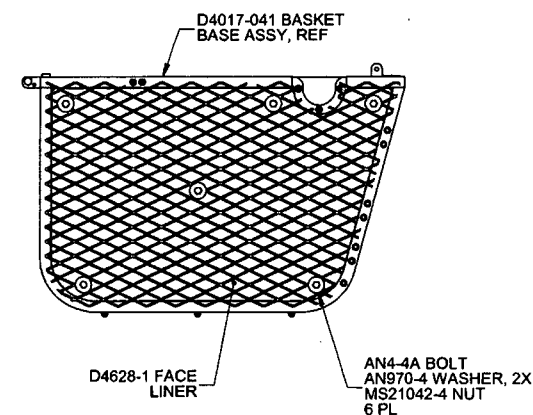
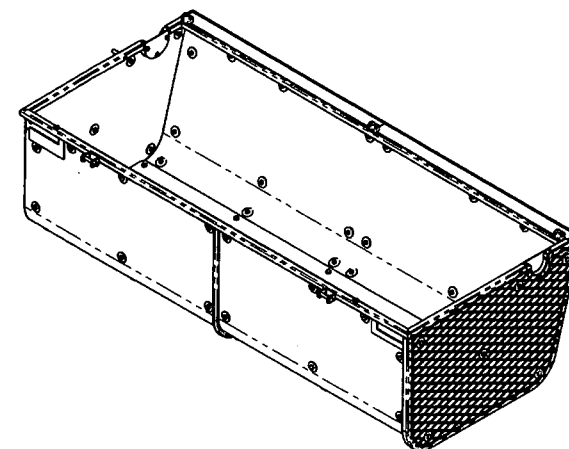
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INSTALLATION OF D4628-3/-5 LINERS
(D4628-5 SHOWN, D4628-3 SIMILAR)

FIGURE 3: INSTALLATION OF DSI 9603-013 LINER KIT - BASKET BASE
(VIEWED FROM TOP, MESH SHOWN PARTIALLY FOR CLARITY)



INSTALLATION OF D4628-1 LINER
(OPPOSITE FACE SIMILAR)

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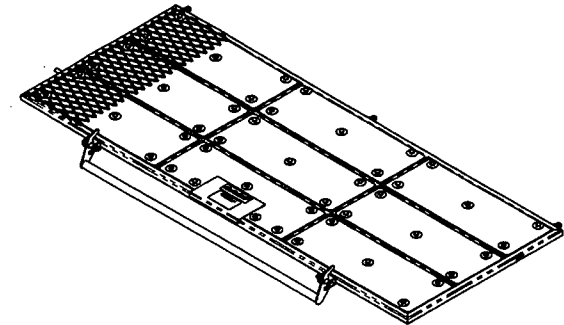
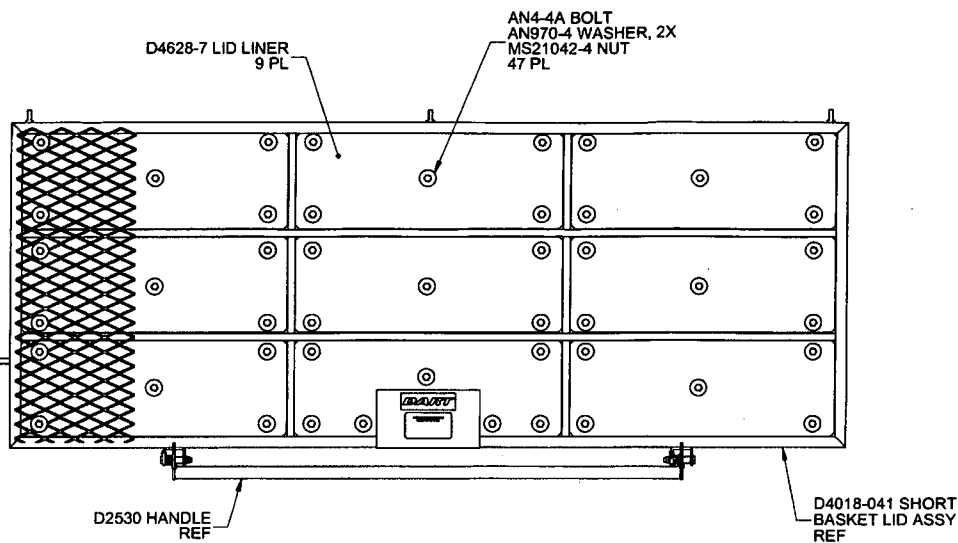


FIGURE 4: INSTALLATION OF DSI 9603-013 LINER KIT - BASKET LID
(VIEWED FROM TOP, MESH SHOWN PARTIALLY FOR CLARITY)

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4.0 INSTALLATION OF LINERS (DSI 9603-013):

- 4.1 Locate the D4628-9 Cover Plate as shown in Figure 3. It is acceptable to trim the D4628-9 to fit as required.
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5.0 PARTS LIST

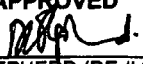
QTY -011	QTY -013	PART NUMBER	DESCRIPTION
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	2	D4628-1	LINER, FACE
	1	D4628-3	LINER, INBOARD
	1	D4628-5	LINER, OUTBOARD
	9	D4628-7	LINER, LID
	2	D4628-9	COVER PLATE
	98	AN4-4A	BOLT
7		AN4-12A	BOLT
6		AN4-14A	SCREW
	196	AN970-4	WASHER
13	98	MS21042-4	NUT
26		NAS1149D0463J	WASHER (OR NAS1149D0432J)

6.0 WEIGHT CHANGE:

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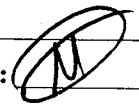
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138569

Page 1

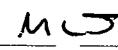
Tuesday, November 03, 2015 9:41:39 AM

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 Revision ID: Stop ***NS2***
 Item Name: Basket Liner
 Start Date: 11/23/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/4/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan:  Date: 11/03 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9603	B								

100 DOCUMENT CONTROL 0.00
100
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP DSI9603-013 CHG001

 NOV 09 2015

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging

NOV 09 2015

120 QC4- 100% Inspect kits for completeness 0.00
120
 QC Memo 0.00
 Quality Control